

Date: Wednesday, 08/10/2008 8:59:27 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY
Job Number : 05048
Estimate Number : 10911
P.O. Number :
This Issue : 08/10/2008 S.O. No. :
Prsht Rev. : NC Part Number : D3405041
First Issue : / / Type : R & D LG FAB Drawing Number : D3405 - PROTOTYPE
Previous Run : 41763 Project Number : N/A
Written By : Drawing Revision : A
Checked & Approved By : Material :
Comment : Est A 05.09.01 New issue KJ/JLM Due Date : 14/10/2008 Qty: 1 Um: Each

Additional Product

Job Number:



FOR ENGINEERING USE ONLY

SCRAP
PROTOTYPE

Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 0.125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 0.1617 sf(s)
304/316 .125 Sheet
(M304S11GA)
Batch: 109358 HB 8-10-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3405
Dwg Rev: PHOTO
Prog Rev: TYPE

HB 8-10-9

(2)

2-Deburr if necessary HB 8-10-9

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-10-9



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



HB 8-10-9 (2)



P-10 (2)

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE


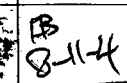
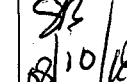

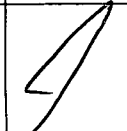



Comment: NC BRAKE
Deburr
Form using DT8204 as per Dwg D3405

SB 08/10/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-041 PAR #: N/A Fault Category: Prod - ENG. CODES NCR: ~~Yes~~ No DQA: lt Date: 08.12.04
 Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: _____

NCR: 05048		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date
08.10.16	2.0	Hole ϕ 0.438 is slightly under size. ϕ 0.433 \rightarrow 0.436, on the bottom of the cut. R.C. Taper in the cut.		Modify the program to cut the hole to drug. drill hole open as per drug i. debur	 08-11-04  08/10/16	 08-11-04	 08/10/16	 08-10-16

NOTE: Date & initial all entries

Date: Wednesday, 08/10/2008 8:59:27 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 05048

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-02	6.0	2 parts scrap due to design change on the length to achieve a special height & radius.	RES/ML	Scrap & destroy. Parts cannot be re-worked to the new specs.	RES/ML 08-12-02		RES/ML	08-12-02

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 05048

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



**ENGINEERING
APPROVAL**



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PT SCRAP OK PT 06.12.02

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-02

00569

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

PROTOTYPEProduct #: D205-634, D204-635 & D206-642Job #: 00569Date: 08.10.07Product Name: GHW LUGSRequested By: AJSDesign Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3405-041	05048	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	D3405-0483 D3405-043	05044	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	D3414-041	05050	LUG ASSY	08.09.23	N	08.10.13	FINISHED CHECK INSTALL PER DSI 9421 REV B	

DART AEROSPACE LTD	Work Order: 05649
Description: LUS ASSEMBLY	Part Number: D3405 D3405-1
Inspection Dwg: D3405-1, Rev: PROTOTYPE	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

x

Prototype

[illegible]

Measured by:	EB
Date:	8-10-9

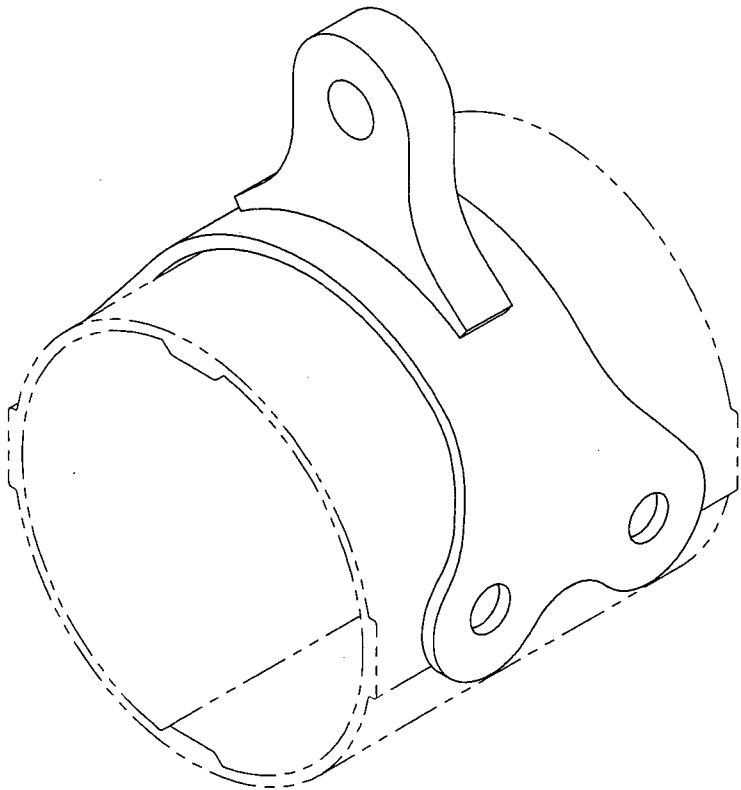
Audited by:	<i>[Signature]</i>
Date:	06-10-16

Prototype Approval:	
Date:	

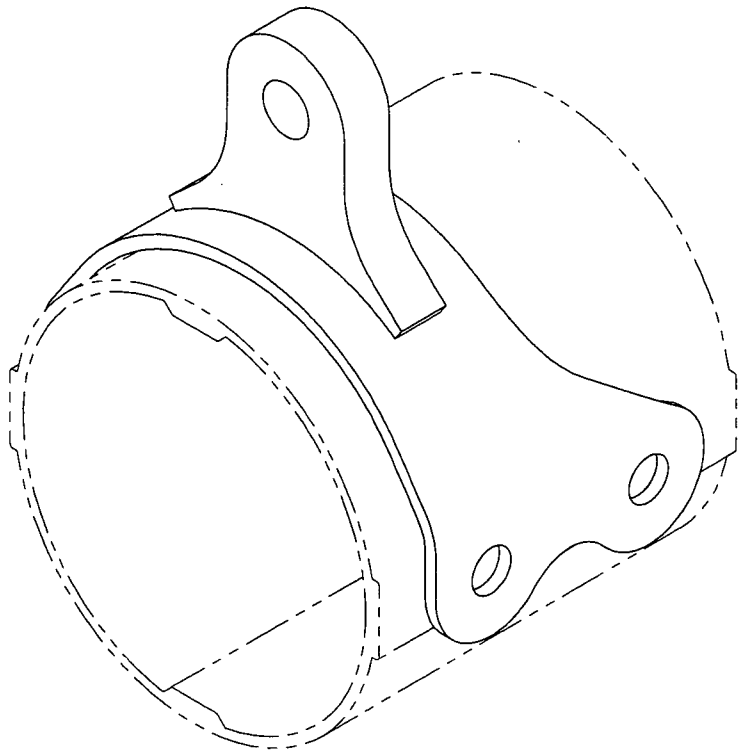
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

REFERENCE ONLY



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

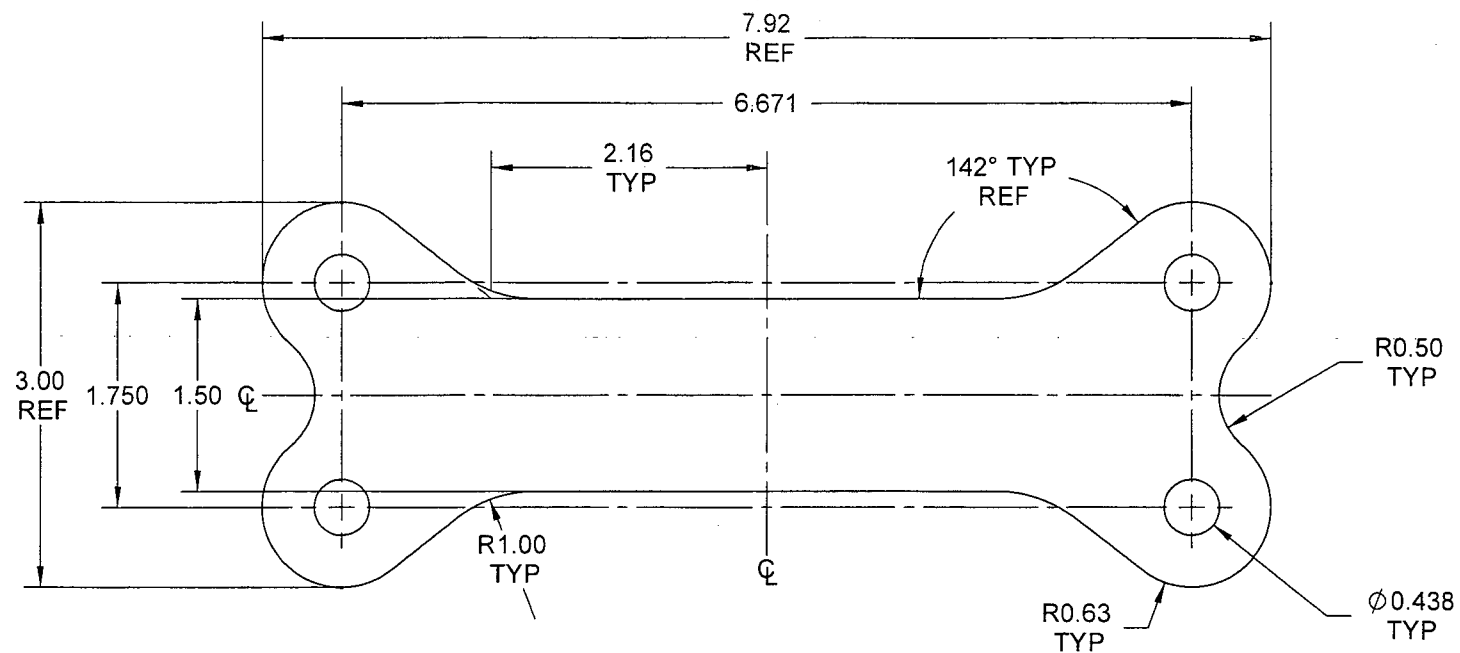


D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

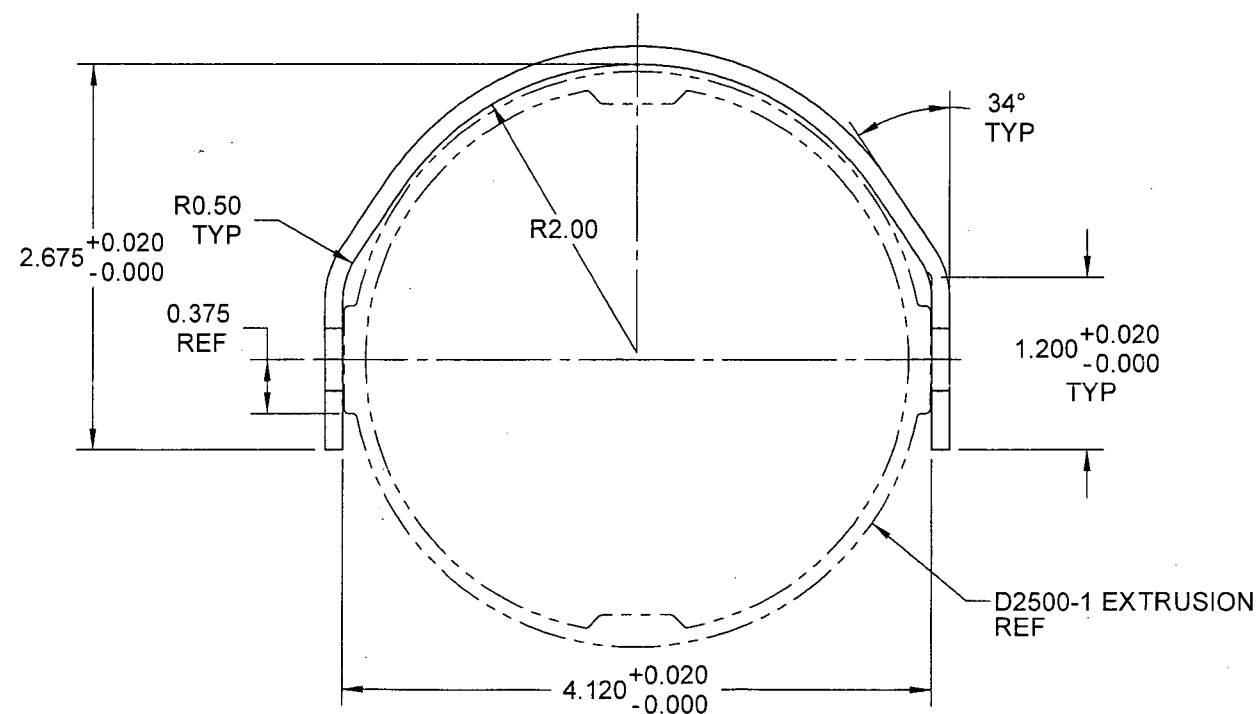
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
DSB 08.10.07

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

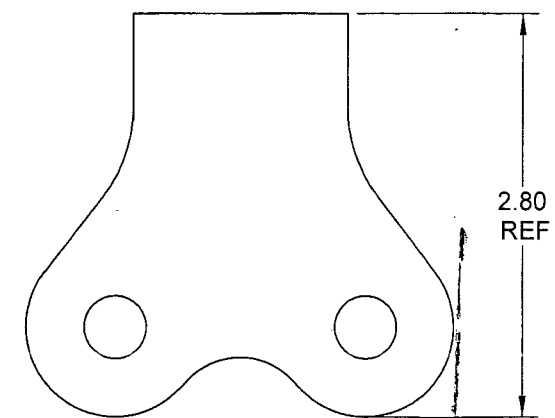
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FCULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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D3405-1F FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

REFERENCE ONLY

PROTOTYPE
PLEASE RETURN ALL ISSUED
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JSS 08.10.07

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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MFG. APPR.		D3405	SHEET 3 OF 4
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8

7

6

5

D3404-1
GHW LUGD3405-1
GHW BRACKET

CL

4.120^{+0.020}_{-0.000}**D3405-041 LUG ASSEMBLY**D3404-1
GHW LUGD3405-3
GHW BRACKET

CL

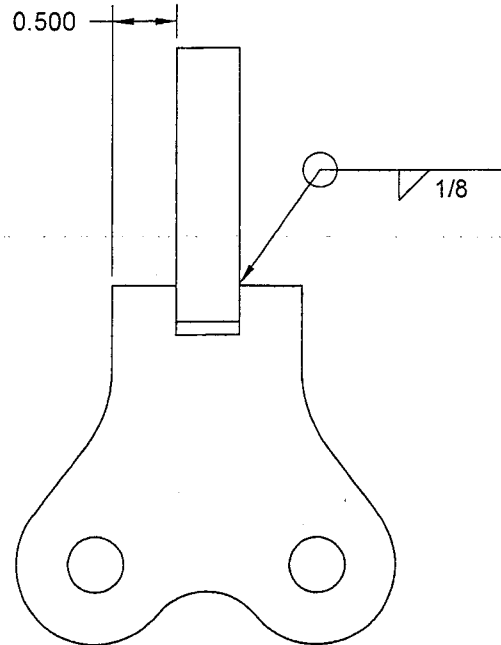
4.120^{+0.020}_{-0.000}**D3405-043 LUG ASSEMBLY**

D

C

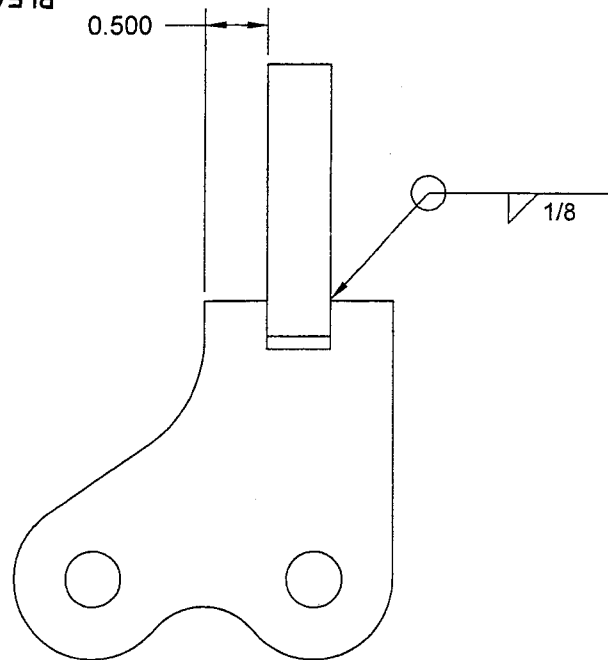
B

A



REVISIONS

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ENGINEERING
PROTOTYPE



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CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
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